Work Order II Wednesday, September	or 17 2014 0:24:45 AM	562-048	*194	1609*							Page 1	
Item ID: D350	62-042	B128809	Accept	*N900	040	100)*	Setup	Start	*/\I	S1*	
Revision ID: Item Name: Step	Weldment	BISSOF					•		Stop		S2*	
Start Date: 9/17/ Required Date: 9/26/ Reference:	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	ID:			•				
	cess Plan:	Date: 14+9-1	7 Tooling:	D:	ate:	_		Run	Start	*N	R1*	
QC	•	Date:	_ SPC (Y/N):	D:	ate:			,	Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D3562	F											
100 *1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	Large Fab		0.00				2		14-9	-17	DYC	_
Large Fab		522 extrusion as per Dwg D3 and bevel ends for welding										
110	QC6- Inspect dimension	ons to drawing	0.00				2				SEP 18	201
X110X QC Quality Control	Memo		0.00				<u>₹</u>) - 89		
120	Chemical Conversion	Coat per OSI005 4.1	0.00					-				
120 HandFinish Hand Finishing	Memo		0.00	:			DX		4-0	9-30	DK	

DQA:		_ Date:										TQAR [®]
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / L		Vork Order uj	ndate only	AEROSPACE
		5000				-	<u> </u>					<u> </u>
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other
Root				Desci	ription of work order update		nitial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design									,		₹,	,
Doc/Data												Marine Marine
quip/Tooling												***:**
landling/Pre						İ						
Material		Ì										
Operator						•						
Offset/Setup		,										
rocess												,
Supplier	_		:			1						
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napproved												
	, ~4 pr					FAL	JLT CAT	EGORY				
Landin	g Gear			٠	General				_	_		_
	Bending				Bend	Ш	Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain		_	Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect	Ш	Hardwa	re		Part Incorred	ct	Temperature/Cure
ai.	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	Inqualified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center	Γ	Positioned V	/rong	
	Heat Trea	et			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread					
	Marks/Ch	natter			Drill Holes		Off-set					
	Turning S	equence			Finish		Out of C	alibration	*		÷ ·	
ſ	Turning Sequence Wave/Twist in Tube				Fit/Function	\Box	Out of S	equence				

124609

N900040100

Date:

Date:

Tool # Plan

Code

Cust Item ID:

Customer:

Tool ID

Page 2

Work Order ID 124609 Wednesday, September 17, 2014 9:24:45 AM Accept Item ID: D3562-042 **Revision ID:** Step Weldment **Item Name:** *9* **Start Date:** 9/17/2014 Start Qty: 2.00 **Required Date: 9/26/2014 Req'd Qty:** 2.00 *9* Reference: Process Plan: Date: Tooling: **Approvals:** SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ **Work Center ID Description Run Hours** 130 QC7-Inspect Chemical Conversion Coat 0.00 *130* 0.00 Memo Quality Control 0.00 140 Small Fab *140* 0.00 Small Fab Memo --- 1- Transfer drill Rivet holes as per dwg D3562. Small Fab 2-Touch-up rivet holes with alodine as per dwg d3562 3-Rivet legs using Scotch-Weld as per dwg D3562. ******Ensure to wipe off any exess magnobond ******

2 14-09-30 DMC

Reject

Number

Run

Accept

Qty

Setup

Start

Reject

Qty

*NR1

Stop

Start

Stop

NR2

Insp.

Stamp

DAS

DATE: AUGUST 2012

DQA:	Date:							_					™ ∂&RT
0.4.61			Data			WORK ORDER NON	-C(ONFO	RMANCE / I			, <u>F</u>	AEROSPACE
QA Closed:			Date:				-			V	/ork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N	- No					Rework Scrap		Į	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering @uality
NCR N	No			,		Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other .
Root		-		•	Desc	ription of work order update		nitial	А	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
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	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs				Bend BOM/Route Broken/Damage/Defect Burrs Contamination			-	· · · · · · · · · · · · · · · · · · ·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled	
	Crushing Heat Treat Inspection Strip in Tube				Countersink Cut Too Short Drawing	-	Misalig Mislabe Misread			Positioned W Power Loss/S		Other	
ļ	_					Drill Holes	-	Off-set					
	Marks/Chatter Turning Sequence Wave/Twist in Tube			_	Finish Fit/Function	-		Calibration equence					

Work Order ID 124609

124609

Page 3

Wednesday, September 17, 2014 9:24:45 AM Accept D3562-042 Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Step Weldment *9* **Start Date:** 9/17/2014 Start Otv: 2.00 **Cust Item ID: Required Date: 9/26/2014** Reg'd Qty: 2.00 *9* **Customer:** Reference: Run Start Process Plan: _____ Date: ____ **Tooling:** Date: Approvals: Stop Date: SPC (Y/N): Date: Reject Reject Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Insp. **Work Center ID Description** Code Otv Otv Number Stamp **Run Hours** QC5- Inspect part completeness to step on W/O 0.00 DAS 150 OCT 1 0 2014 24 *150* 9-89 0.00 Memo Quality Control 0.00 160 Large Fab 2x CC/4-10-02 2x DMC 14-10-02 *160* 0.00 Large Fab Memo -1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as Large Fab per QSI 024. A/RAluminum Rod K128956 2-Grind end cap welds flush as per Dwg D3562 DAS OCT 0 2 2014 170 QC10- Inspect visual per QSI004- ground welds 0.00 24 9-89 *170* 0.00 QC Memo Quality Control

DQA:	Date:						_						*	
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / L		Work Order u	ndate only		AEROSPACE
		—				DISPOSITION						•		
Work Orde	er:					DISPOSITION				AGAINST	DEPARTMENT	/PROCESS		
Part N	No	_				Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.		Engineering Quality
NCR N	No					Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier		Other
Root					Desci	ription of work order update		Initial	Ac	ction	Sign &			
Cause	Dat	e	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Design Doc/Data										•				
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[Bendi	ng				Bend		leolio/e	rogram	Γ	Outside Dim	ansions	\Box	Pressure/Forced
}	_	_	t Concer	ntric		BOM/Route		Grain	108.4	-	Over/Under			Set-up
<u> </u>	 i					Broken/Damage/Defect		Hardwa	re	.	Part Incorred		\vdash	Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		1	ion Incomplete/U	Inqualified	Part Lost/Mi		—	Weld	
•	Cuffs				Contamination		1	ions Incomplete/		Part Moved	-	_	Wrong Stock Pulled	
Ī	Crushing				Countersink		1	ned/off center	<u> </u>	Positioned V			0	
Ī	Heat	reat				Cut Too Short		Mislabe		F	Power Loss/:	· ·		Other
	Insped	tion	Strip in	Tube		Drawing		Misread	1	_		- (
	Marks	/Cha	atter			Drill Holes		Off-set						
	Turning Sequence				Finish		Out of 0	Calibration				,		
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence					

Work Order ID 124609

124609

Page 4

Wednesday, September 17, 2014 9:24:45 AM Accept D3562-042 Item ID: *N900040100* Setup Start **Revision ID:** Stop Step Weldment **Item Name:** *2* Start Oty: 2.00 **Start Date:** 9/17/2014 **Cust Item ID: Required Date: 9/26/2014** Req'd Qty: 2.00 *9* **Customer:** Reference: Start Run Process Plan: _____ Date: ___ Date: Approvals: Tooling: Stop SPC (Y/N): Date: OC: Date: Reject Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Sequence ID/ Number Stamp Qty Oty **Work Center ID** Description **Run Hours** Code OCT 0 2 2014 DAS QC5- Inspect part completeness to step on W/O 0.00 180 24 α *120* 9-89 0.00 Memo Quality Control Chemical Conversion Coat per QSI005 4.1 0.00 190 They son 2 *190* 0.00 HandFinish Memo Hand Finishing White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 200 2 \$ 14-10-2. *200* 0.00 Powdercoat Memo START TIME: Powder Coating **OVEN TEMPERATUR**

FINISH TIME:

DQA:		_ Date:											*	NA PT
					WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:	- 	Date:					T			W	ork Order up	odate only		
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework]		Skid-tube	Crosstube	Г]	Water Jet		Engineering
Part N	lo				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
NCR N	10				Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite		Rec/Sto	re/Packaging Supplier		Other
Root				Descr	ription of work order update		Initial	Act	ion		Sign &		\neg	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	า	QC Inspector
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quip/Tooling		1												
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ŀ	Centre No	ot Concer	ntric		BOM/Route	_	Grain	TOGIATII			Over/Under	F	$\overline{}$	Set-up
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ţ	Crushing				Countersink	\vdash		ned/off center		 	Positioned W	L/rong		ong otook i uned
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Ī	Marks/Ch	atter		-	Drill Holes		Off-set							
	Turning Se	equence			Finish		Out of C	Calibration						
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of S	equence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord Wednesday, Se		4609 \(\) 24:45 AM		*124	1609*							Page 5
Item ID: Revision ID: Item Name:	D3562-042 Step Weldmer	nt		Accept	*N900	040	10	N *	_	Start Stop	*N	S1* S2*
Start Date: Required Date Reference:	9/17/2014 e: 9/26/2014	Start Qty: 2.00 Req'd Qty: 2.00	* ? *		Cust Item I Customer:	D:		,				
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		nte:				Start Stop	*N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description Wing Walk as per dwg 0	QS1005 4.4 Batch <u> </u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
910 HandFinish Hand Finishing		Memo		0.00				X 2	- -			MIGOG
220 *220*		QC3- Inspect Part Finish	h	0.00				(3)				DAS 38 9-89 /4-/0-
QC Quality Control		Memo		0.00								-
230		Identify as per dwg & S	tock Location.	0.00				- 7				DA (/ / 30

230
Packaging

Packaging

DQA:	Date:						ONEO	DA445105 / 11				***	TRAC
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE	Work Order u	pdate only	7	AEROSPACE
Work Orde	or.				DISPOSITION				AGAINST	DEPARTMENT	/PROCESS		
Part N	lo				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro	Water Jet od. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Desci	ription of work order update		Initial	Act	tion	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desci	ription	Date	Verification		QC Inspector
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	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Se	t-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct [Te	mperature/Cure
	Crimp/Kir	k/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified	Part Lost/Mi	ssing	w.	eld
	Cuffs				Contamination		Instructi	ions Incomplete/L	Jnclear	Part Moved	Γ	w	rong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center	[Positioned V			
	Heat Trea	t			Cut Too Short		Mislabel	led	[Power Loss/	Surge [Ot	her
	Inspection	n Strip in	Tube		Drawing		Misread		-				
L	Marks/Ch	atter			Drill Holes		Off-set						
	Turning Se	equence			Finish		Out of C	alibration					
	Wave/Tw	ist in Tuh	e		Fit/Function		Out of S	earronco					

Work Ord Wednesday, Sep		24609 014 9:24:45 AM		*194	1609*							Page 6	<u> </u>
tem ID: Revision ID: (tem Name:	D3562-042 Step Weldme			Accept	*N900	040	100)*	_	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	9/17/2014 : 9/26/2014	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:							
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:]		Start Stop		R1* R2*	
Sequence ID/ Work Center I 240 *クム∩*	D	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	
QC Quality Control		Memo		0.00							-1-J-2 - - -	mf o	. Z

240

Quality Control

DQA:			. Date:				•		2444105 / 1						TRAC
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / L		Mork Ore	lor ur	odate only	<u> </u>	AEROSPACE
QA Closed.			Date.								vvork Orc	iei uļ	date only	<u>—</u>	
Work Orde	er:					DISPOSITION				AGAINST	DEPARTM	1ENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube			Water Jet	:	Engineering
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Thern	noforming	Finishing	Red	:/Sto	re/Packaging		Other
NCR N	۷o. <u>-</u>					Suspected Unapproved			Large Fab	Composite[Supplier		
Root					Desci	ription of work order update	1	nitial	Ac	ction	Sign	&			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Da	te	Verificatio	n	QC Inspector
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ļ		Centre No	t Concer	ntric		BOM/Route		Grain		1			tolerance	<u> </u>	Set-up
		Cracks			\square	Broken/Damage/Defect		Hardwa		-	Part Inc			<u>_</u>	Temperature/Cure
	Crimp/Kink/Ripple/Wave			\vdash	Burrs		· ·	on Incomplete/U	· · · · · · · · · · · · · · · · · · ·	Part Lo		ssing	<u></u>	Weld	
	Cuffs			\vdash	Contamination			ions Incomplete/	h-	Part M				Wrong Stock Pulled	
		Crushing				Countersink			ned/off center	Ļ	Positio		-		7
	Heat Treat			\square	Cut Too Short	_	Mislabe		1	Power	Loss/S	Surge	L_	Other	
	Inspection Strip in Tube				Drawing	-	Misread								
θ,	Marks/Chatter			\vdash	Drill Holes	-	Off-set								
	Turning Sequence				-	Finish			alibration						
	Wave/Twist in Tube					Fit/Function		Out of S	equence						

Picklist Print

Wednesday, September 17, 2014 9:24:44 AM

Work Order ID: 124609

124609

Parent Item:

D3562-042

D3562-042

Parent Item Name:

Step Weldment

Start Date: 9/17/2014

Required Date: 9/26/2014

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A IPP rev B

New Issue 06-11-09 JLM

ECN 987

07.10.09 EC

verified by: DD

ECN1048 07-12-18 DD verified by: EC IPP Rev:C

IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E

13.06.03 PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	88.0000	1	2		2.10	1// 00
D2622-12 Step Extrusion	20C								**			DMC	14-9-1
				Location		Loc	<u>Qty</u>	Loc Code					
				HALL			84				_		
					100575		22						

		<u>Location</u>	<u>170</u>	t Qty	Lot Code			
		HALL		84				_
		109575		32				_
		119621		52			$Q_{\mathscr{S}}$	_
		WA003		4				_
		101765		1				_
		115141		3				_
Manufactured	No		140	Each	47.0000	2	4	

D2734

D3560-042

D2734

Manufactured

140

47.0000

**

CC 14-10-1.

Step End Plate

		Location	Loc	<u>Oty</u>	Loc Code	
		WA003		47		
		(119286)		35		
		119498		11		
		99709		1		
Manufactured	No		140	Each	4.0000	1
						**

D3560-042 Arm Weldment

> Location Loc Oty Loc Code WA003 108848 119556 3

DQA:			Date:							•				NA PT		
						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:						* :	1	Work Order up	odate only	<u> </u>			
Work Order:						DISPOSITION		İ								
	_		**			Rework			Skid-tube	Water Jet			Engineering			
Part N	۱o.					Scrap		Skid-tube Cross Machining Sma			Prod. Eng. Coor.			Quality		
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other		
NCR No.						Suspected Unapproved			Large Fab	Composite						
Root					Desci	ription of work order update	!	Initial	Ac	tion	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector		
Design																
Doc/Data																
Equip/Tooling	_															
Handling/Pre																
Material	_									•						
Operator																
Offset/Setup																
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Training	_															
Transport																
Unapproved																
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Landir 1	_					General		1		٦				1 .		
1		ending				Bend			rogram	-	Outside Dim		<u> </u>	Pressure/Forced		
	_	entre No	t Concer	ntric		BOM/Route		Grain		-	Over/Under		<u> </u>	Set-up		
	Cracks					Broken/Damage/Defect			Hardware		Part Incorred			Temperature/Cure		
	Crimp/Kink/Ripple/Wave					Burrs		1	on Incomplete/U	· -	Part Lost/Mi	-		Weld		
	Cuffs					Contamination		1	ions Incomplete/I	Unclear	Part Moved			Wrong Stock Pulled		
	Crushing					Countersink		1 -	ned/off center	 -	Positioned W			l _{au}		
-		eat Trea		T la ·	\vdash	Cut Too Short		Mislabe		L	Power Loss/	Surge	L_	Other		
}	_	spection	-	rube	\vdash	Drawing		Misread	I		<u> </u>					
}		1arks/Ch				Drill Holes		Off-set								
}		urning Se				Finish		ł	Calibration							
	Wave/Twist in Tube					Fit/Function		Out of S	equence							

Picklist Print

Wednesday, September 17, 2014 9:24:45 AM

Page 2

Work Order ID: 124609

124609

Parent Item:

D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 9/17/2014

Required Date: 9/26/2014

Start Qty: 2.00

Required Qty: 2.00

D3560-044

Manufactured

Purchased

140

Each 2.0000

D3560-044

Arm Weldment

MS20600-AD4W5

**

DMC 14-09-30

Location

Loc Qty 2 2 Loc Code

No

160

Each 744.0000

32

**

64

DMC 14-09-30

MS20600-AD4W5

Blind Rivet

Location Loc Qty ST310 372 372

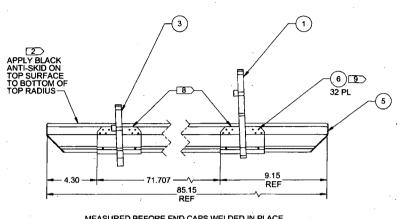
m129820 WA003 372

372 m129472

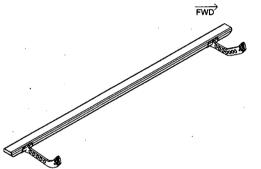
Loc Code

DQA:			Date:										TART
0.6			D-1			WORK ORDER NON				AEROSPACE			
QA Closed:			Date:					,		V	/ork Order up	odate only	
Work Ord	ork Order:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part I	- - No					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	⊣	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	۷o					Use-as-is Suspected Unapproved		Thermoforming Finishin Large Fab Composit			Rec/Stor	Other	
Root					Desci	ription of work order update		Initial	A	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Design													
Doc/Data													:
Equip/Tooling													
Handling/Pre													
Material	Щ									•			
Operator													
Offset/Setup													
Process													
Supplier	Щ												
Training	Щ												
Transport													
Unapproved			<u> </u>										
							FAI	JLT CAT	EGORY				
Landi	ng G	iear				General		,			-	_	_
	_	Bending			<u> </u>	Bend	$ldsymbol{ld}}}}}}}$	Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	L_	Grain	Grain		Over/Under tolerance		Set-up
	Cracks					Broken/Damage/Defect		Hardware			Part Incorred	t _	Temperature/Cure
		Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspecti	on Incomplete/L	Jnqualified	Part Lost/Mis	· -	Weld
	$\overline{}$	Cuffs				Contamination	$\overline{}$	1	ions Incomplete,		Part Moved	Ĺ	Wrong Stock Pulled
	-	Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong _	
	-	Heat Trea			<u> </u>	Cut Too Short		Mislabe	led		Power Loss/S	Surge	Other
	_	Inspection	•	Tube	<u> </u>	Drawing	\vdash	Misread					
	_	Marks/Ch				Drill Holes	_	Off-set					
	_	Turning Se	•			Finish		Out of C	Calibration				•
	Wave/Twist in Tube					Fit/Function		Out of S	equence				

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MEASURED BEFORE END CAPS WELDED IN PLACE



D3562-041 LH STEP ASSEMBLY

NOTES:

D

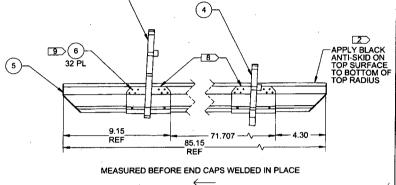
- 1) MATERIAL: N/A

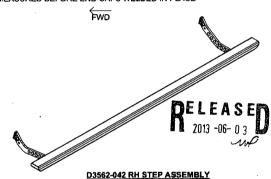
- 2) FINISH:

 i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
 GREY SANDTEX (4.3.5.6) OR
 BLACK SANDTEX (4.3.5.7) OR
 GREEN SANDTEX (4.3.5.7) OR
 GREEN SANDTEX (4.3.5.7) OR
 GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

 ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 8.79 IBS
 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN
 THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
 SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL
 CONVERSION COAT BEFORE RIVETING





DESIGN	11)	DART AFROSP	ACE IT	rn.					
REV.	DE	SCRIPTION	BY	DATE					
Α	NEW ISSUE	CP	06.09.26						
В	ARMS NOW RIVETED TO	CP	07.01.15						
С	NOW MAGNOBOND, ADD	D2808, REMOVE 4 RIVETS	CP	07.06.19					
D	REMOVE D2808 SPACER SOLIDWORKS	NOTE; REDRAW IN	DC	07.11.16					
E	ADD QTY(2) TO D2734 EN	D PLATE ON 03562-042	PH 08.01.						
F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED DW 13.0 NOTE 9 AND SHEET 2								

REV.	_	DESCRIPTION	D1	DATE					
DESIGN	P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
DRAWN	DW								
CHECKED	SP	DRAWING NO.		REV. F					
MFG. APPR.	W.	D3562		SHEET 1 OF 2					
APPROVED	76	TITLE		SCALE					
DE APPR.	4	STEP ASSEMBLY		NTS					
DATE 13.0	05.15	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT BY PRIVATE AND COMPENENTIAL BY BY BY LED ON THE LEDRESS COMPINENTIAL THE NOT TO BE USED FOR ANY PURPORE OF COMPENENTIAL THE TANK WITH THE PERSON WITHOUT							

ITEM No.	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3562-041	LH STEP ASSEMBLY
		X	D3562-042	RH STEP ASSEMBLY
1	1		D3560-041	ARM WELDMENT
2		1	D3560-042	ARM WELDMENT
3	1		D3560-043	ARM WELDMENT
4		1	D3560-044	ARM WELDMENT
5	1	1	D3562-1	STEP ASSEMBLY
6	32	32	MS20600AD4W5	RIVET

1

D

С

DQA:	DQA: Date:				- WORK ORDER MONI CONFORMANCE (1120 ATE											
QA Closed: Date:						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only										
						DISPOSITION										
Work Orde	er: _						,				DEPARTMENT/PROCESS					
						Rework			Skid-tube	Crosstube	-	Water Jet			Engineering	
Part N	10			· .		Scrap			Machining	Small Fab	-	Prod. Eng. Coor.			Quality	
NICD A	1 -					Use-as-is		Thern	noforming	Finishing	_	Rec/Sto	re/Packaging		Other	
NCR N	NO					Suspected Unapproved]		Large Fab	Composite]	Supplier			
Root					Descr	ription of work order update		nitial	Ac	ction		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date Verificatio		1	QC Inspector	
Design																
Doc/Data																
Equip/Tooling																
Handling/Pre	\dashv															
Material	_								ļ							
Operator																
Offset/Setup Process																
Supplier	\dashv															
Training																
Transport	\dashv															
Unapproved									·							
· · · · · · · · · · · · · · · · · · ·							FAL	JLT CAT	TEGORY			<u> </u>			· · · · · · · · · · · · · · · · · · ·	
Landir	ng Ge	ar				General										
	В	ending				Bend			Folio/Program			Outside Dimensions			Pressure/Forced	
	c	entre No	t Concen	ıtric		BOM/Route	Grain				Over/Under	tolerance		Set-up		
	Cı	racks				Broken/Damage/Defect	Broken/Damage/Defect					Part Incorred	ct [Temperature/Cure	
	Crimp/Kink/Ripple/Wave					Burrs		Inspecti	on Incomplete/U	Inqualified		Part Lost/Mi	_		Weld	
	Cuffs					Contamination	_		ions Incomplete/			Part Moved	L		Wrong Stock Pulled	
		rushing			Ш	Countersink		Misalig	ned/off center			Positioned V				
	Heat Treat					Cut Too Short	$\boldsymbol{\vdash}$	Mislabe		1		Power Loss/Surge			Other	
	Inspection Strip in Tube					Drawing	\vdash	Misread	i							
	_	larks/Ch				Drill Holes	\vdash	Off-set								
		urning Se			-	Finish			Calibration							
	Wave/Twist in Tube					Fit/Function		Out of S	Out of Sequence							

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